

# Work Order ID 110232

December-17-13 9:18:51 AM

**\*110232\***

Page 1

Item ID: D2747 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Set Screw 100  
 Start Date: 12/17/13 Start Qty: 50.00 **\*50\*** Cust Item ID:  
 Required Date: 12/17/13 Req'd Qty: 50.00 **\*50\*** Customer:  
 Reference:

Approvals: Process Plan: ML5 Date: 13- Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2747	Rev B

100 PURCHASING 0.00  
**\*100\***  
 Purchasing Memo 0.00  
 Purchasing Issue P/O: 22437 3/8"-24 UNF SS Set Screw 7/8" to 1"  
 longPossible Supplie: McMaster CarrP/N:92311A639Material release note  
 required CL 13/12/19 100

110 Receive & Inspect for Damage & Mat'l Certs 0.00  
**\*110\***  
 Packaging Memo 0.00  
 Packaging Ensure material release note is attached P 13/12/20 (100)

120 QC6- Inspect dimensions to drawing 0.00  
**\*120\***  
 QC Memo 0.00  
 Quality Control DAS 27 9-89 13/12/20 100

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 110232

December-17-13 9:18:51 AM

**\*110232\***

Page 2

Item ID: D2747 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Set Screw  
Start Date: 12/17/13 Start Qty: 50.00 **\*50\*** Cust Item ID:  
Required Date: 12/17/13 Req'd Qty: 50.00 **\*50\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>ST017</u>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00				100X	DAS 28 9-89	13-12-27	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

PL14-01-7  
07/01/2014

PL14-01-7

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
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# Picklist Print

December-17-13 9:18:51 AM

Page 1

Work Order ID: 110232

Parent Item: D2747

Parent Item Name: Set Screw

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: B05.08.22ReformatKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
92311A639 SS SET SCREW		Purchased	No				Each	0.0000		<del>50</del> 100			

12/13/20 (100)

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

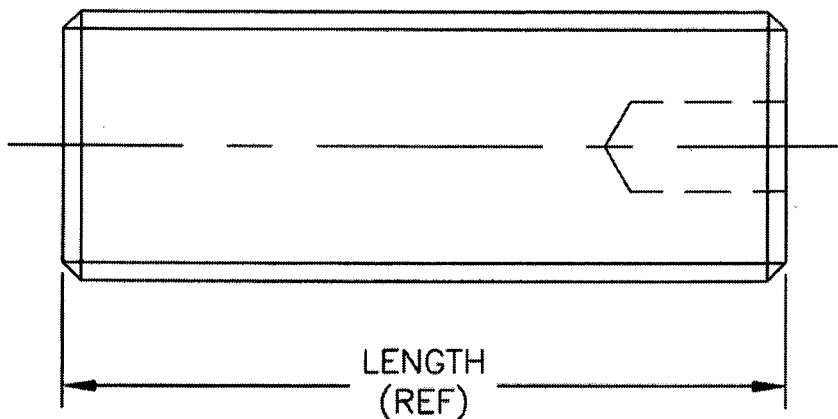
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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**DART**

DESIGN DS	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2747	REV. B SHEET 1 OF 1
DATE 05.03.09		TITLE SET SCREW	SCALE NTS
A	98.08.26	NEW ISSUE	
B	05.03.09	REDRAWN, STAINLESS STEEL ONLY	

**RELEASED**  
05.08.09 *[Signature]***D2747 SET SCREW**

- 1) TYPE: HEX SOCKET HEAD SET SCREW
- 2) MATERIAL: STAINLESS STEEL
- 3) THREAD: 3/8"-24 UNF
- 4) LENGTH = 7/8" TO 1"
- 5) FINISH: NONE
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

110232MCS  
13-12-17

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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO22437

Purchase Order Date 12/19/2013

PO Print Date 12/19/2013

Page Number 1 of 3

**Order From :**

VU-MCM001

**Ship To :** DART AEROSPACE LTD

MCMASTER-CARR SUPPLY CO,  
P.O. BOX 7690  
CHICAGO, IL 60680-7690  
US

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**Contact Name**

**Vendor Phone** 330 995 5500

**Ship To Contact**

**Ship To Phone**

**Ship Via:** FedEx PI collect

**Ship Acct:**

**Buyer**

**Customer POID**

**Customer Tax #**

**Terms**

**Currency**

**FOB**

Chantal Lavoie

10127-2607

Net 10

USD

FCA - (Free Carrier)

*REVISED*

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	92311A639  AS PER DWG D2747 REV. B B110232	SS SET SCREW	12/20/2013 Yes 12/20/2013		100.00 ✓ Each	\$0.64	\$63.60
Line Total:							\$63.60
2	95606A170  AS PER DWG D3631 REV. A B110258	Washer	12/20/2013 Yes 12/20/2013		100.00 Each	\$0.09	\$8.60
Line Total:							\$8.60
3	71400-20	53355T71 SHOP COAT SIZE: 42	12/20/2013 Yes 12/20/2013		1.00 Each	\$31.04	\$31.04

Note:

12/19/2013





200 Aurora Industrial Pkwy  
Aurora OH 44202-8087  
330-995-5500  
cle.sales@mcmaster.com

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada

Purchase Order  
PO22437

Page 1 of 2

Order Placed By  
Chantal Lavoie

12/19/2013

McMaster-Carr Number  
5833211-01

Line	Description	Ordered	Shipped
1	92311A639 18-8 Stainless Steel Cup Point Set Screw, 3/8"-24 Thread, 1" Long, Packs of 10 Your Part Number: B110232	10 Packs	10
	Unit Price: \$6.36 Extended Price: \$63.60		
2	95606A170 Nylon 6/6 General Purpose Flat Washer, Off-White, 7/16" Screw Size, .69" OD, .02"-.04" Thickness, Packs of 100 Your Part Number: B110258	1 Pack	1
	Unit Price: \$8.60 Extended Price: \$8.60		
3	53355T71 Polyester/Cotton Blend Shop Coat, Dark Blue, Size 42 Your Part Number: 71400-20	1 Each	1
	Unit Price: \$31.04 Extended Price: \$31.04		
4	92375A325 Type 316 Stainless Steel Reusable Hairpin Cotter Pin, Fits 7/16" to 3/4" Pin Diameter, 2-5/8" Length, Packs of 10 Your Part Number: 71550-10 JESSE WATER JET	5 Packs	5
	Unit Price: \$10.13 Extended Price: \$50.65		

LNS A81			
2 - 695 - 07	26 - 02	A639	10 PK 1
2 - 623			2
3 - 636			3
3 - 321			4

Dart Aerospace Ltd

EXP  
INV  
NAFTA



40 lbs  
8 lines

Me

12x12x12

FW1WBP24  
12/19/2013  
12:23/12:57  
661  
Cycle 42

